Work Orde		5737		*11	5737*						Page 1	
Revision ID:	D3595-063-39 Rubber Cushio			Accept	*N900	040	100	<b>)</b> * ፡	Setup Sta Sto		S1* S2*	
	4/03/14 4/04/14	Start Qty: 10 Req'd Qty: 10		\00* \00*	Cust Item :	ID:				N	. 12	
Approvals:		n: MLJ	Date:   Y −€	<u>NY-0</u> Tooling: SPC (Y/N):		ate:		F	Run Sta Sto	" 'I/I	R1* R2*	
Sequence ID/ Work Center II		Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp	
Draw Nbr	Revi	sion Nbr										
D3595	A										DAS -	
*100 *100* Waterjet  FLOW CNC Waterje		FLOW WATER JE  Memo		0.00				100			23 9-89   4-C	9.
vo. 125"		Dwg I Prog I	Rev: <b>A</b>									
110		QC2- Inspect parts	off machine FAI/FAIB	0.00							DAS <b>23</b>	
*11 \(\hat{\O}\)* QC  Quality Control		Memo	•	0.00				100			9-89	
120		QC8- Inspect parts	- second check	0.00							DAS <b>38</b>	

0.00

Memo

Quality Control

DQA:		Date:													
QA Closed:		Date:			WORK ORDER NON-	-CC	ONFO	RMANCE / UPDATE	\٨/	ork Order up	ndate only	$\neg$	AEROSPACE		
2,110,000		Dute.								•					
Work Orde	r:				DISPOSITION			AGAIN	ST DE	PARTMENT	/PROCESS				
				_	Rework	1		Skid-tube Crosstu	be		Water Jet	$\Box$	Engineering		
Part N	o. <u> </u>				Scrap			Machining Small F	ab	Pro	d. Eng. Coor.		Quality		
					Use-as-is		Therr	noforming Finishi	ng	Rec/Sto	re/Packaging		Other		
NCR N	o			_	Suspected Unapproved			Large Fab Compos	ite		Supplier				
Root				Desci	ription of work order update	П	nitial	Action		Sign &		Т			
Cause	Date	Step	Qty		or non-conformance	Ch	ief Eng	Description		Date	Verification	,	QC Inspector		
Design															
Doc/Data															
Equip/Tooling															
Handling/Pre															
Material					i										
Operator					•						:	ĺ			
Offset/Setup		1				İ				·					
Process															
Supplier	_														
Training															
Transport												İ			
Jnapproved															
						FAI	ULT CA	TEGORY							
Landin	g Gear				General					<b>-</b>					
L	Bending				Bend		Folio/F	Program		Outside Dim	ensions		Pressure/Forced		
	Centre No	ot Conce	ntric		BOM/Route		Grain			Over/Under	tolerance		Set-up		
L	Cracks				Broken/Damage/Defect		Hardwa	ire		Part Incorre	ci _	_ ՝	Temperature/Cure		
1	Crimp/Kir	nk/Ripple	:/Wave		Burrs		Inspect	ion Incomplete/Unqualified		Part Lost/Mi	ssing	<u></u> '	Weld		
	Cuffs				Contamination	L	Instruct	tions Incomplete/Unclear	L	Part Moved	L	'	Wrong Stock Pulled		
Į	Crushing				Countersink		4	gned/off center		Positioned V	Vrong _				
Ĺ	Heat Trea	at			Cut Too Short		Mislabe	eled		Power Loss/	Surge		Other		
	Inspectio	n Strip in	Tube		Drawing		Misread	d							
	Marks/Ch	natter			Drill Holes		Off-set								
	Turning S	equence			Finish		Out of 0	Calibration							
	Wave/Tw	ist in Tul	e e		Fit/Function		lout of	Sequence							

Work Ord		15737		*11 <i>5</i>	5737*	_						Page 2	2
Item ID: Revision ID: Item Name:	D3595-063			Accept	*N900	<b>040</b>	100	)*	Setup	Start Stop	171	S1* S2*	<del></del>
Start Date: Required Date Reference:	4/03/14 e: 4/04/14	<b>Start Qty:</b> 100.00 <b>Req'd Qty:</b> 100.00	*10 *10		Cust Item I Customer:	D:							
Approvals:	Process P	Plan:	Date:	Tooling: SPC (Y/N):		ate:		]	Run	Start Stop	<b>^</b> IV	R1* R2*	
Sequence ID/ Work Center 1	ID	Operation Description Identify as per dwg & Sto		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Rej Qty		Reject Number	Insp. Stamp	DAS
*120* Packaging Packaging		Memo		0.00				100	Х —			-9-11	DAS 26 9-89
140		OC21 Final Inspection	Morte Order Pologo	0.00	•					. 1	/ /	) )	∕\

0.00

Memo

\*140\* QC

Quality Control

MLJ 14.09-11

DQA:		_ Date:										TQAC
QA Closed:		Date:			WORK ORDER NON-	-CC	ONFO	RMANCE / UPDATE	147	ant Ordan un	ndata anku 🖵	AEROSPACE
QA Closed.		Date.					,		VV	ork Order up	date only	
Work Orde	er:				DISPOSITION			AGAINST	DE.	PARTMENT	/PROCESS	
					Rework	1		Skid-tube Crosstube		1	Water Jet	Engineering
Part N	lo.				Scrap			Machining Small Fab	-	Pro	d. Eng. Coor.	Quality
					Use-as-is		Thern	noforming Finishing		Rec/Sto	re/Packaging	Other
NCR N	lo				Suspected Unapproved			Large Fab Composite			Supplier	
Root		Τ		Desci	ription of work order update		nitial	Action		Sign &		T
Cause	Date	Step	Qty		or non-conformance	Ch	ief Eng	Description		Date	Verification	QC Inspector
Design												
Doc/Data												
Equip/Tooling								,				
Handling/Pre												
Material		<u> </u>										
Operator										!		
Offset/Setup												
Process												
Supplier												
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Transport	_											
Unapproved						<u> </u>				l		
				•••		FA	ULT CAT	regory				<del></del>
Landir F	ng Gear			_	General		1 .		_	1	_	٦
}	Bending	_			Bend		ŧ .	Program		Outside Dim	<del></del>	Pressure/Forced
}		ot Concer	ntric		BOM/Route	$\vdash$	Grain		<u> </u>	Over/Under	<del> </del>	Set-up
}	Cracks	1.45.		-	Broken/Damage/Defect	<u> </u>	Hardwa		_	Part Incorred	<u> </u>	Temperature/Cure
}		nk/Ripple	:/Wave		Burrs	<u> </u>	1 '	ion Incomplete/Unqualified		Part Lost/Mi	ssing	Weld
}	Cuffs			_	Contamination		4	ions Incomplete/Unclear	_	Part Moved		Wrong Stock Pulled
-	Crushing			-	Countersink	$\vdash$	1	ned/off center	_	Positioned V		٦
	Heat Tre				Cut Too Short		Mislabe		<u></u>	Power Loss/	Surge	Other
-	Inspection	•	Tube	<u> </u>	Drawing	<u> </u>	Misread				<u>.</u>	
-	Marks/Cl				Drill Holes	l-	Off-set					
-		Sequence		<u> </u>	Finish		1	Calibration				
	Wave/Tv	vist in Tub	e e	1	Fit/Function	1	IOut of 9	Sequence				

## **Picklist Print**

April-04-14 10:18:04 AM

Work Order ID: 115737

Parent Item Name:

\*115737\*

Parent Item:

D3595-063-395

Rubber Cushion

\*D3595-063-395\*

**Start Date:** 4/03/14

Required Date: 4/04/14

Start Qty: 100.00

Required Qty: 100.00

**Comments:** 

IPP Rev:A 10.11.03 as per dwg revA DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3595		Manufactured	No			100	sf	522.7004	0.0196	(3)			<b>DAS</b>
* <b>D3595</b> * Rubber Cushion (\$ Per Sq Ft	)								**			<u></u>	<b>23</b> 14-0
, , , , ,				Location		Loc	<u>Oty</u>	Loc Code					
				MAT052		522							

<u>Location</u>	Loc Qty	Loc Code	
MAT052	522.7004		
68954	23.707		
84209	12.4134		
94539	486.58		94539

Page 1

DQA:		_ Date:										1	
					WORK ORDER NON-	-CC	ONFO	RMANCE / UPDATE					AEROSPACE
QA Closed:		Date:							W	ork Order up	odate only		
Work Orde	r:				DISPOSITION			AGAINST	DE	PARTMENT,	/PROCESS		
				_	Rework	1		Skid-tube Crosstube		]	Water Jet	٦,	Engineering
Part N	0.				Scrap			Machining Small Fab		Pro	d. Eng. Coor.	┥ '	Quality
	•	*			Use-as-is	1		noforming Finishing	-	1	re/Packaging		Other
NCR N	o				Suspected Unapproved			Large Fab Composite	-		Supplier		
D = +4	<del></del>	1	T					T					
Root	<sub>D-4-</sub>	<b>C</b>		Desci	ription of work order update	i	Initial	Action		Sign &			
Cause	Date	Step	Qty		or non-conformance	Ch	ief Eng	Description		Date	Verification		QC Inspector
Design	{												
Doc/Data	-												
Equip/Tooling Handling/Pre	$\dashv$		,								i	1	
Material	$\dashv$										-		
Operator	$\dashv$												
Offset/Setup													
Process	_												
Supplier	$\dashv$												
Training	7												
Transport	7												
Unapproved						:							
						FAI	ULT CAT	regory		<u> </u>			
Landin	g Gear				General								
	Bending				Bend		Folio/P	Program		Outside Dim	ensions	Pro	essure/Forced
	Centre N	lot Conce	ntric		BOM/Route		Grain			Over/Under	tolerance	Se	t-up
	Cracks				Broken/Damage/Defect		Hardwa	re		Part Incorred	ાં	Те	mperature/Cure
·	Crimp/Ki	ink/Ripple	/Wave		Burrs		Inspect	ion Incomplete/Unqualified		Part Lost/Mi	ssing	\w	eld
_	Cuffs			L	Contamination		4	ions Incomplete/Unclear		Part Moved		w	rong Stock Pulled
_	Crushing				Countersink	-	• "	ned/off center		Positioned V		_	
<u> </u>	Heat Tre				Cut Too Short	_	Mislabe			Power Loss/	Surge	Ot	her
<u> </u>	<b>—</b>	on Strip in	Tube	<u> </u>	Drawing		Misread	d		<del></del>			
-	Marks/C				Drill Holes		Off-set						
-		Sequence		<u> </u>	Finish	<u>_</u>	ł	Calibration					
	Wave/Tv	vist in Tub	oe		Fit/Function		Out of S	Sequence					!

DART AEROSPACE LTD	Work Order:	115757
Description: Rubber Cushion	Part Number:	D3595-063-395
Inspection Dwg: D3595 Rev: A		Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.63	+/-0.030	0.635	_		ν	Jkmoi
3.95	+/-0.030	3.952	_		V	
0.125	+/-0.010	0.125			V	
				i		
			<u> </u>			
					,	
	DAS		DAS	<u></u>		

| Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das | Das

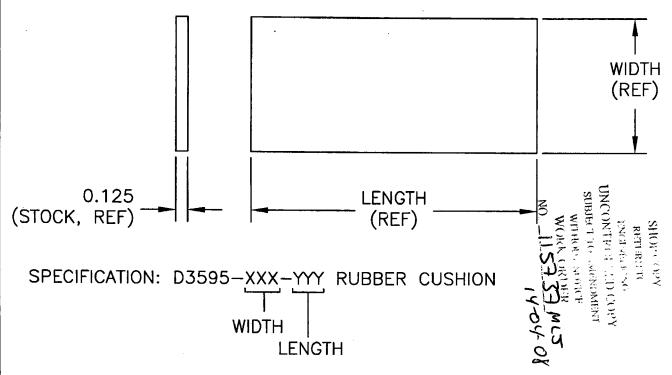
Rev	Date	Change	Revised by in	Approved
Α	08.01.23	New Issue	KJ/EC/DD 🐆	



DESIG	PH	DRAWN BY	DART AEROSPACE L HAWKESBURY, ONTARIO, CANADA	.TD
CHEC	KED ://	APPROVED //	DRAWING NO.	REV. A
	THE STATE OF THE S	th	D3595	SHEET 1 OF 1
DATE			TITLE	SCALE
07.0	2.07	=	RUBBER CUSHION	NTS
Α		07.02.07	NEW ISSUE	

FELEASED 07.02.14-

## SPECIFICATION CONTROL DRAWING



EG: 0.75"x4.30" RUBBER CUSHION = D3595-075-430

## NOTES

1) MATERIAL: BLACK NEOPRENE SHEET, 0.125 THICK,

80 DUROMETER (REF DART SPEC. M-NEO80-S.125)

FINISH: NONE

3) ALL DIMENSIONS ARE IN INCHES

4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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